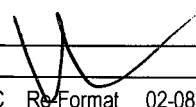


Date: Friday, 06/06/2008 7:35:04 AM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HELI-UTILITY BASKET LH
Job Number	: 37723		
Estimate Number	: 12554		
P.O. Number	:	Part Number	: D205541044
This Issue	: 06/06/2008 S.O. No. :	Drawing Number	: IIN D205-541 REV F
Prsht Rev.	: NC	Project Number	:
First Issue	: 11/03/2008 Type : LARGE FAB ASSY	Drawing Revision	: F
Previous Run	: 28985	Material	:
Written By	: 	Due Date	: 17/03/2008 Qty: 1 Um: Each
Checked & Approved By	:		
Comment	: Est Rev:C Re-Format 02-08-30 KJ		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: Photocopy bluefile & type labels per PPPD205-541-043

CHG002



JLD 08.6.11

2.0	D2512	Basket Lid 205/350
-----	-------	--------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Basket Lid 205/350

B 37723A

SB 08/06/11 (1)

3.0	D3053042	212 Basket Base Assembly
-----	----------	--------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
212 Basket Base Assembly

B 37723B

SB 08/06/11 (1)

4.0	D2022101	Spacer
-----	----------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spacer

Batch: 37521

SB 08/06/11 (1)

5.0	D2258300	Label
-----	----------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Placard

Batch: 37538

SB 08/06/11

SB

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 06/06/2008 7:35:04 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-UTILITY BASKET LH

Job Number: 37723

Part Number: D205541044

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2332041

Lid Prop Assembly 6.69" long



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Lid Prop Assembly 6.69"

Batch: 38597

SP

7.0

D2530

Handle Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Handle Weldment

Batch: 37853

SP

8.0

D2535

Spring



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spring

Batch: 37071

SP

9.0

D2537

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bushing

Batch: 37605

SP

10.0

D2931

Bumper



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bumper

Batch: 21139

SP

11.0

AN316A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: 106815

SP

12.0

AN47A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: 107321

8/6/11

(X)

SP

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 06/06/2008 7:35:04 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-UTILITY BASKET LH

Job Number: 37723

Part Number: D205541044

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

13.0	AN422A	Bolt
------	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Bolt
Batch: 104937

SL

14.0	AN424A	Bolt
------	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Bolt
Batch: 104547

SP

15.0	AN517A	Bolt
------	--------	------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Bolt
Batch: 106815

SO

16.0	AN960JD416	Washer
------	------------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Washer
Batch: 107939

SL

17.0	AN960JD416L	Washer
------	-------------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Washer
Batch: 107008

SL

18.0	AN960JD516	Washer
------	------------	--------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Washer
Batch: 107959

SL

19.0	AN960JD8	Washer
------	----------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Washer
Batch: 107091

8/6/11

(1x)

SL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 06/06/2008 7:35:04 AM

Date: Friday, 06/06/2008 7:35:04 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-UTILITY BASKET LH

Job Number: 37723

Part Number: D205541044

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

AN9704

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Batch: 107715

scf

21.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch: 107644

scf

22.0

MS21042L4

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: 107478

scf

23.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: 107939

scf

24.0

MS20600AD4W3

Cherry Rivets



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Cherry Rivets

Batch: 18071

8/6/11

(1x)

scf

25.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per Dwg.

Eff 08/06/11 @

26.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

1000-12

5. PARTS LIST

Qty -043	Qty -044	Part Number	Description
X		D205-541-043	HELI-UTILITY-BASKET LH
	X	D205-541-044	HELI-UTILITY-BASKET RH
2	2	D2022-101	SPACER
1	1	D2199-1	STRUT
1	1	D2199-23	STRUT
1	1	D2199-25	STRUT
1	1	D2258-300	LABEL
1	1	D2332-041	PROP ASSEMBLY
1	1	D2498	MOUNTING LUG
1	1	D2499	MOUNTING LUG
1	1	D2512	BASKET LID ASSEMBLY
2	2	D2515	BUSHING
1	1	D2530	HANDLE ASSEMBLY
2	2	D2535	SPRING
2	2	D2537	BUSHING
2	2	D2931	BUMPER
1	1	D3052-1	MOUNTING LUG
1		D3053-041	BASKET BASE ASSEMBLY, LH
	1	D3053-042	BASKET BASE ASSEMBLY, RH
1	1	* D2446	* SIGN PLATE
1	1	* D2509	* LINER (BASE)
1	1	* D2511	* LINER (END)
2	2	AN3-16A	BOLT
4	4	AN4-7A	BOLT
3	3	AN4-12A	BOLT
9	9	AN4-13A	BOLT
2	2	AN4-14A	BOLT
1	1	AN4-22A	BOLT
1	1	AN4-24A	BOLT
1	1	AN5-7A	BOLT
1	1	AN5-13A	BOLT
4	4	AN5-17A	BOLT
30	30	AN960JD416	WASHER
7	7	AN960JD516	WASHER
2	2	AN960JD8	WASHER
4	4	AN970-4	WASHER
2	2	MS20600AD4W3	RIVET
2	2	MS21042L3	NUT (OR MS21042-3)
20	20	MS21042L4	NUT (OR MS21042-4)
6	6	MS21042L5	NUT (OR MS21042-5)
6	6	* MS24693S272	* SCREW
6	6	* A3235-020-935	* WASHER
6	6	* NAS679A3W	* NUT
4	4	* MS20470AD4-8	* RIVET
42	42	* MS20600AD4W4	* RIVET

* OPTIONAL EQUIPMENT

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 37723

Date: Tuesday, 13/05/2008 9:27:58 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	BEARPAW KIT (19"X16")
Job Number :	39220		
Estimate Number :	12664		
P.O. Number :		Part Number :	D206559011
This Issue :	13/05/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2435 REVE1
First Issue :	/ /	Project Number :	N/A
Previous Run :	37535	Drawing Revision :	E1
Written By :		Material :	
Checked & Approved By :	<u>JLD 08.5.13</u>	Due Date :	10/06/2008
Comment :	Est Rev:C 04.02.17 Blank size changed KJ/JLM Est Rev:D 07-01-02 Was K10007 JLM Est Rev:E 08-05-05 up a chg DD verified by:EC		

Qty: 6 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPPD206-559-011 CHG006

S 08/06/16 08.5.16 JLD

2.0	MFG ENGINEERING	MFG ENGINEERING
-----	-----------------	-----------------



Comment: MFG ENGINEERING

Program Batch Number

27.05.28

3.0	MUHMWB10	UHMW 1" Black
-----	----------	---------------



Comment: Qty.: 4.6830 sf(s)/Unit Total: 28.0980 sf(s)

blank: 19.500" x 16.00" x 1.00" thick (+0.030/-0.000) per DSK086-3

Material: Black UHMW 1"

(MUHMWB10)

Batch: 7108013

See Attached last page
08/06/16

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1

Note: (2) Bearpaw for (1) Kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio and Dwg D2435 Identify as D2435

3-Deburr

Y.A. 08/06/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (19"X16")

Job Number: 39220

Part Number: D206559011

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

M.A

08/06/03

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SS 08/06/05

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

8.0

D2182B

Rubber Cushion



Comment: Qty.: 1.6660 f(s)/Unit Total : 9.9960 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D2182B050 Rubber Cushion

35769 ✓

SS 08/06/06 (x6)

9.0

D2274

Radius Block



Comment: Qty.: 8.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 D2274 Radius Block

2 D2435(ref only) Bearpaw

B37630 x28
B32015 x20
~~38827 x8~~
~~39525 x4~~ B39220

SS 08/06/06 (x6)

10.0

D2438

Clamp



Comment: Qty.: 4.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D2438 Clamp

B37562

SS 08/06/06 (x6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (19"X16")

Job Number: 39220

Part Number: D206559011

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

D2529

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch
8 D2529 Washer B37210 x 20
B21587A x 8
B32025 x 20

JS 08/06/06 (x6)

12.0

AN415A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch
8 AN4-15A Bolt M107737

JS 08/06/06 (x6)

13.0

AN417A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 48.0000 Each(s)

Bolt

Batch: M105653

JS 08/06/06 (x6)

14.0

AN960JD416

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 96.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch
16 AN960JD416 Washer M107939

JS 08/06/06 (x6)

15.0

MS21042L4

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch
8 MS21042L4 Nut (or -4) M104683 x4
M106051 x12
M103914 x32

JS 08/06/06 (x6)

16.0

QS200M44S

Clamp



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch
2 QS200M44S Clamp M107035 M108077
1 Paperwork package

JS 08/06/06 (x6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 13/05/2008 9:27:58 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (19"X16")

Job Number: 39220

Part Number: D206559011

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

S 08/06/06 (x10)

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPPD206-559-011

Location: B

8/6/06

(x) SP

19.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/06/10

Job Completion



CL08/06/09

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

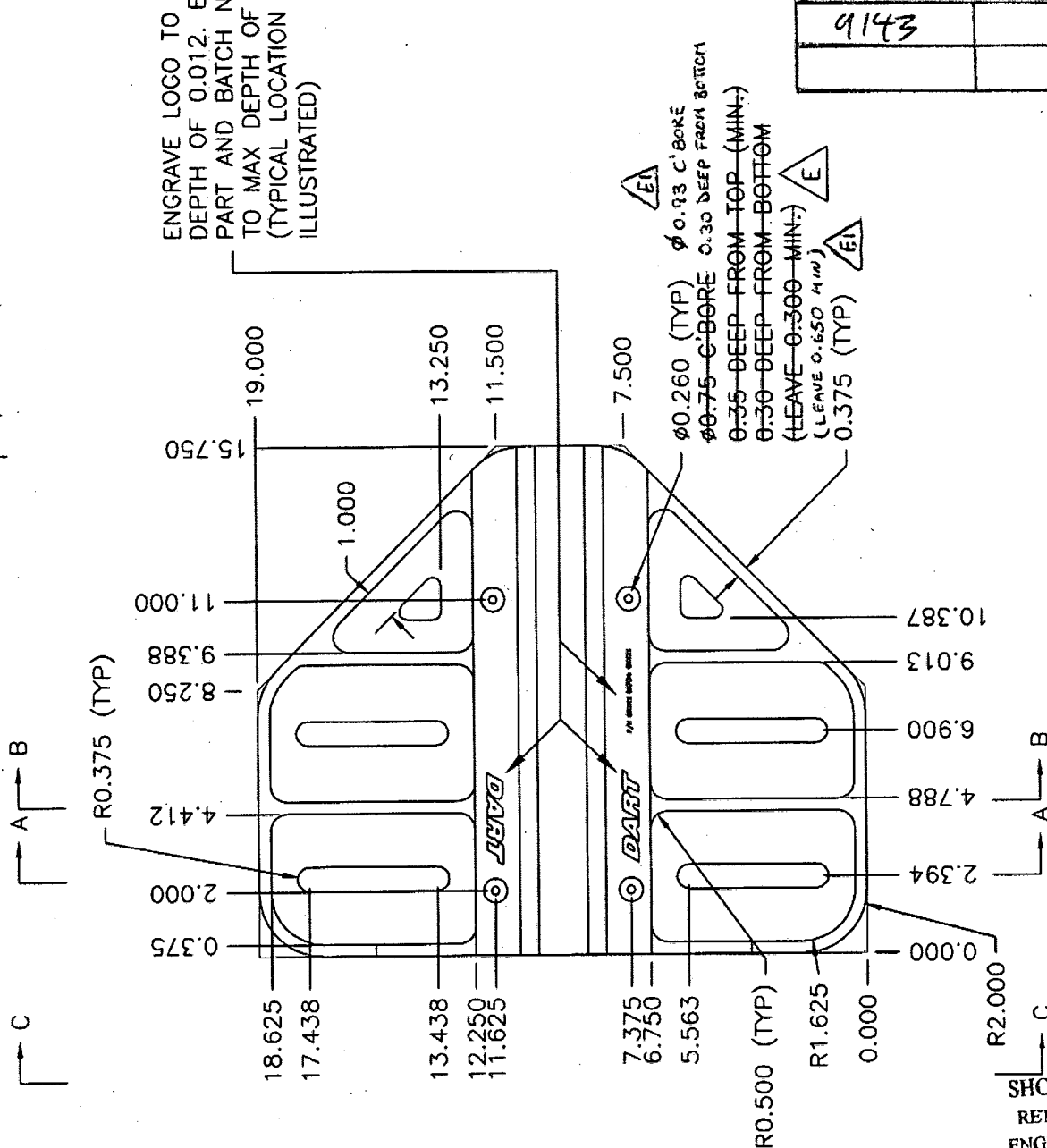
NOTE: Date & initial all entries

DART

DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED KE	DRAWING NO. D2435	REV. E SHEET 1 OF 2
DATE 98.05.19		TITLE BEARPAW	SCALE 1:5
A	96.01.24	NEW ISSUE	
B	96.03.26	CHANGE BORE AND C'BORE DEPTH	
C	97.05.07	CHANNEL & C'BORE DEPTH CHANGED	
D	97.10.17	R1.5 BORE WAS R2.637 (TSR A469)	
E	98.05.19	CHANGE C'BORE, R1.58 WAS R1.50	

EFFECTIVE DEOS

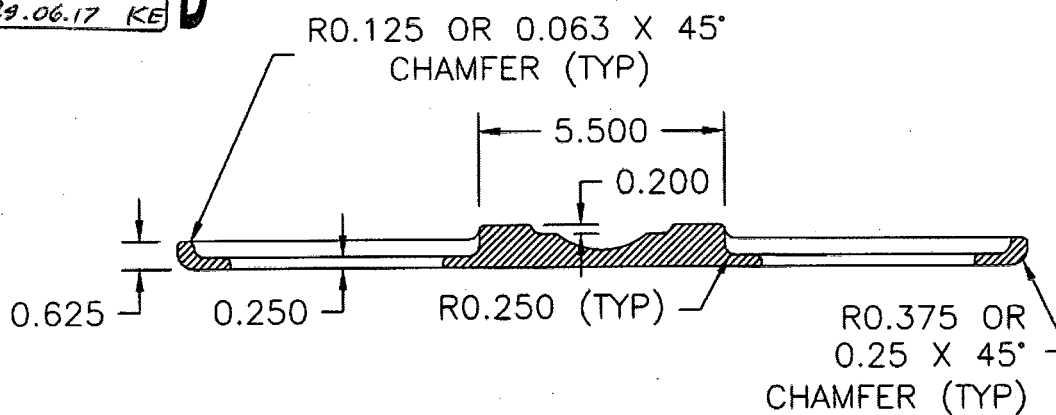
9143	

RELEASED
98.06.17 KEENGRAVE LOGO TO MAX
DEPTH OF 0.012. ENGRAVE
PART AND BATCH NUMBERS
TO MAX DEPTH OF 0.010.
(TYPICAL LOCATION AS
ILLUSTRATED)MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 39220

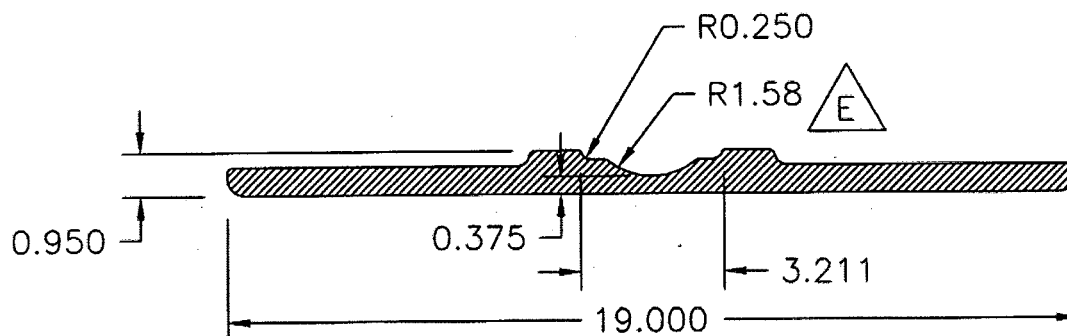


DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>DR</i>	APPROVED <i>KE</i>	DRAWING NO. D2435	REV. E SHEET 2 OF 2
DATE 98.05.19	TITLE BEARPAW		SCALE 1:4

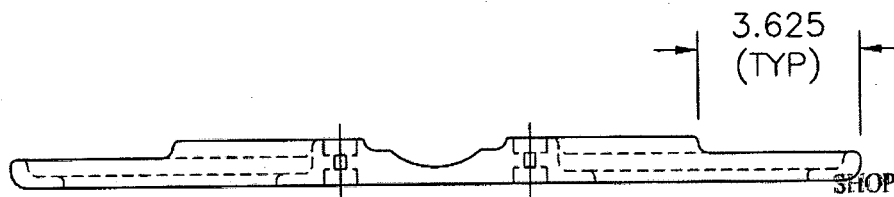
RELEASED
99.06.17 KE



SECTION A-A



SECTION B-B



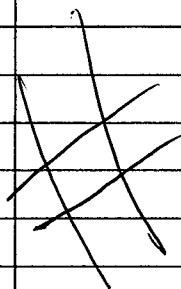
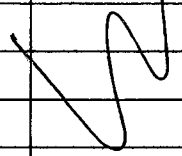
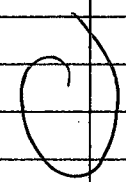
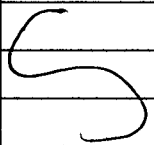
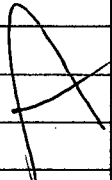
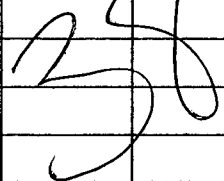
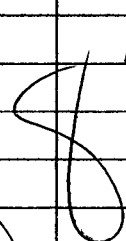
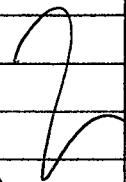
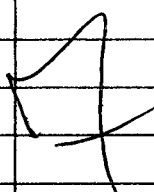
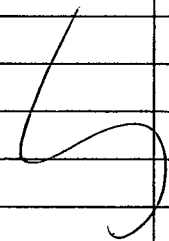

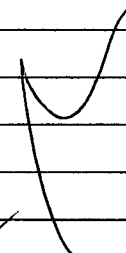
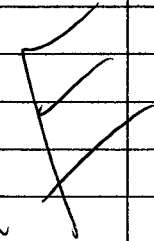
SECTION C-C

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 39220

DART AEROSPACE LTD	Work Order:	39220
Description: Bear paw	Part Number:	D2435
Inspection Dwg: D2435 Rev: E1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article** ☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
<p>    </p> <p>   </p> <p>     </p> <p>     </p>						
<p>See ATTACHED copy</p>						

Measured by:		Audited by:		Prototype Approval:	
Date:		Date:		Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART AEROSPACE LTD		Work Order: 38827
Description: Bearpaw		Part Number: D2435
Inspection Dwg: D2435 Rev: E1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.057 x 45°	✓			
B	5.500	+/-0.030	5.500	✓			
C	0.200	+/-0.030	0.200	✓			
D	R0.250	+/-0.030	R 0.250	✓			
E	0.250	+/-0.010	0.250	✓			
F	0.625	+/-0.030	0.610	✓			
G	0.25 x 45°	+/-0.030	0.260 x 45°	✓			
H	0.375	+/-0.010	0.376	✓			
I	19.000	+/-0.030	19.000	✓		tape	
J	0.950	+0.030/-0.010	0.950	✓			
K	Ø0.260	+0.005/-0.000	Ø0.260	✓			
L	Ø0.930	+/-0.030	Ø0.931	✓			
M	0.30	+0.030/-0.000	0.309	✓			
N	0.375	+/-0.030	0.377	✓			
O	7.375	+/-0.030	7.360	✓			
P	4.250	+/-0.010	4.250	✓			
Q	2.000	+/-0.030	1.998	✓			
R	9.000	+/-0.010	8.999	✓			
S	15.750	+/-0.030	15.750	✓		tape	

Measured by: M.A./DSP	Audited by: Jmt	Prototype Approval:	N/A
Date: 08/06/03	Date: 08/06/03	Date:	

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O K10007	KJ/RF	

Date: Friday, 6/6/2008 10:23:15 AM

User: Chantal Lavoie

JOB HISTORY : DETAIL

Job Number	: 39220	Customer	: Dart Helicopters Services
Estimate Number	: 12664	DWG Name	: BEARPAW KIT (19"X16")
Purchase Order #	:	Part Number	: D206559011
Complete Date	: / / : : AM	DWG Number	: D2435 REVE1
		Rev.	: E1

DUE DATE		ORDERED	DELIVERED	
6/10/2008		6	0	

3.0 MUHMWB10-UHMW 1" Black INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
5/30/2008	AUCL01: Auclair, Guillaume	MUHMWB10	28.098		\$537.45	Lot # 108013 Qty. 28	
Subtotal:		QTD:	0	CTD:	28	\$537.45	

4.0 HAAS1 Internal Operation							
DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach. Cost
6/3/2008	AUCL01: Auclair, Guillaume	Run	0.000	1.46	\$25.77	1.46	63.65
6/4/2008	AUCL01: Auclair, Guillaume	Run	0.000	4.97	\$87.72	4.97	216.67
6/4/2008	AUCL01: Auclair, Guillaume	Run	6.000	2.79	\$49.24	2.79	121.62
Subtotal:		QTD:	6	CTD:	0	9.22	\$564.67

8.0 D2182B-Rubber Cushion INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
6/6/2008	SAUV02: Sauve, Amy	D2182B	9.000		\$9.85	Lot # 35769 Qty. 9	
Subtotal:		QTD:	0	CTD:	9	\$9.85	

9.0 D2274-Radius Block INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
6/6/2008	SAUV02: Sauve, Amy	D2274	48.000		\$54.29	Lot # 32015 Qty. 20 Lot # 37630 Qty. 28	
Subtotal:		QTD:	0	CTD:	48	\$54.29	

10.0 D2438-Clamp INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
6/6/2008	SAUV02: Sauve, Amy	D2438	24.000		\$153.68	Lot # 37562 Qty. 24	
Subtotal:		QTD:	0	CTD:	24	\$153.68	

11.0 D2529-Washer INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
6/6/2008	SAUV02: Sauve, Amy	D2529	48.000		\$1.49	Lot # 21587A Qty. 8 Lot # 32025 Qty. 20 Lot # 37210 Qty. 20	
Subtotal:		QTD:	0	CTD:	48	\$1.49	

12.0 AN415A-Bolt INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
6/6/2008	SAUV02: Sauve, Amy	AN415A	48.000		\$9.65	Lot # 107737 Qty. 48	
Subtotal:		QTD:	0	CTD:	48	\$9.65	

13.0 AN417A-Bolt INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
6/6/2008	SAUV02: Sauve, Amy	AN417A	48.000		\$14.46	Lot # 105653 Qty. 48	
Subtotal:		QTD:	0	CTD:	48	\$14.46	

AEROSPACE LTD		Work Order:	38327
Description: Bearpaw		Part Number:	D2435
Inspection Dwg: D2435	Rev: E1	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.057 x 45°	✓			
B	5.500	+/-0.030	5.500	✓			
C	0.200	+/-0.030	0.200	✓			
D	R0.250	+/-0.030	R0.250	✓			
E	0.250	+/-0.010	0.250	✓			
F	0.625	+/-0.030	0.610	✓			
G	0.25 x 45°	+/-0.030	0.260 x 45°	✓			
H	0.375	+/-0.010	0.376	✓			
I	19.000	+/-0.030	19.000	✓		tape	
J	0.950	+0.030/-0.010	0.950	✓			
K	Ø0.260	+0.005/-0.000	Ø0.260	✓			
L	Ø0.930	+/-0.030	Ø0.931	✓			
M	0.30	+0.030/-0.000	0.309	✓			
N	0.375	+/-0.030	0.377	✓			
O	7.375	+/-0.030	7.360	✓			
P	4.250	+/-0.010	4.250	✓			
Q	2.000	+/-0.030	1.998	✓			
R	9.000	+/-0.010	8.999	✓			
S	15.750	+/-0.030	15.750	✓		tape	

Measured by:	BA/DSP	Audited by:	JMK	Prototype Approval:	N/A
Date:	08/06/03	Date:	08/06/03	Date:	

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O K10007	KJ/RF	✱

Date: Tuesday, 3/11/2008 7:52:41 AM
 User: Kim Johnston

Process Sheet

12

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 350/212/130 BASKET LID
Job Number	: 37723A		
Estimate Number	: 10193		
P.O. Number	:	Part Number	: D2512
This Issue	: 3/11/2008 S.O. No. :	Drawing Number	: D2512 <u>UNDER REVIEW</u>
Prsht Rev.	: NC	Project Number	:
First Issue	: 1/1 Type : LARGE FAB ASSY	Drawing Revision	: D2
Previous Run	: 37413A	Material	:
Written By	:	Due Date	: 3/17/2008 Qty: * 1 Um: Each
Checked & Approved By	: <u>08 03 11</u>		
Comment	: Rev Est: M 03.01.31 Added D2012-117 for D130-701-041 KJ/RF		
	: Est Rev: N 06.04.05 Added level21 EC		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304TS0750W065 304 SQ Tube.75x.75x.065W



Comment: Qty.: 45.7594 f(s)/Unit Total : 45.7594 f(s)

Pick:

3/4"x3/4" 304/316 SS tube .065" wall

Batch: ~~M106367~~ M106818

0.045
06.03.11
M106818
(16)

SAD 08/05/02

2.0 D31663 Basket Hoop



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description

1 D3166-3 Basket Hoop

Batch

~~B38780~~

SAD 08/06/05 (1)

3.0 D2506 Placard



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description

1 D2506 Label Plate

Batch

~~B37448~~

PL 08.06.05

4.0 D23271 Spacer Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description

2 D2327-1 Bushing

Batch

~~B36920~~

PL 08.06.04

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2512 PAR #: N/A Fault Category: Prod / Ins. Lag NCR: Yes No DQA: 75 Date: 08/06/13
 QA: N/C Closed: 75 Date: 08/06/13

NCR: 37723A		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/06/05	6.0	During welding welder welded a D2581 in the wrong position PL for lack of attention	<i>[Signature]</i>	Remove Bracket and Scrap. Re weld in correct position D2581 B# <u>B37248</u> at <u>(1)</u>	<i>[Signature]</i> 08/06/05 <i>[Signature]</i> 08/06/05	<i>[Signature]</i> 08/06/05	<i>[Signature]</i>	<i>[Signature]</i> 08/06/05

NOTE: Date & initial all entries

Date: Tuesday, 3/11/2008 7:52:42 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/212/130 BASKET LID

Job Number: 37723A

Part Number: D2512

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D22321

Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description
2 D2232-1 Hinge plate

Batch
035684

Pl 08.06.04

6.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description
2 D2581 Mounting Bracket

Batch
337248

Pl 08.06.04

*EPK2
Previous Pick*

7.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 18.0000 sf(s)/Unit Total : 18.0000 sf(s)

Pick:

Qty Part Number Description
18 sf M304EX0.75-16F Expanded Metal

Batch
17107856

SAD 08/06/05 ①

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut 3/4" x 3/4" square tubing as per Dwg D2512

SAD

08/05/12

①

2-Cut (4) D2236 From D3166-3

3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305

5-Weld as per Dwg D2512 using Welding Table and corner Jig Deburr as required

Pl 08.06.05

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-06-10

10.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

8 08/06/10 ②

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/11/2008 7:52:42 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/212/130 BASKET LID

Job Number: 37723A

Part Number: D2512

Job Number:



Seq. #: Machine Or Operation: Description :

11.0 POWDER COATING POWDER COATING



M107925



10/06/2008

006 15.28

398.5

337723A

SI2

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M-1 08/06/11

12.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4

Spray: m/08/28

WW Batch: m/02892

F2 08/06/11

13.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08/06/11

14.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: G-1

08/06/11

15.0 QC21 FINAL INSPECTION/W/O RELEASE



08/06/12

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-08-12

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

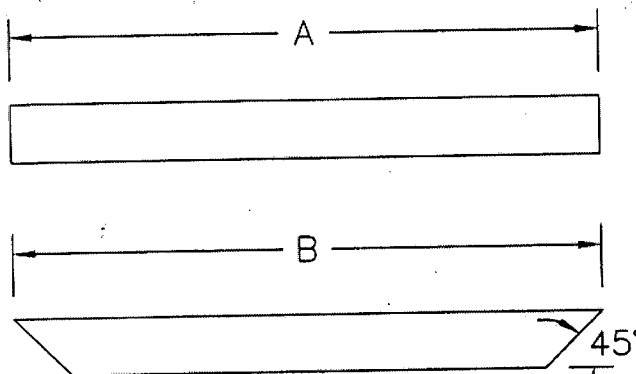


DESIGN BW	DRAWN BY UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2512	REV. D SHEET 1 OF 4
DATE 01.04.19		TITLE BASKET LID ASSEMBLY (350/212)	SCALE NTS
A	95.11.21	NEW ISSUE	
B	96.05.24	ADDED LATCH CHANNEL & LABEL PLATE	
C	99.07.06	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS, INCORP. DEO 9074.	
D	01.04.19	CHANGE HINGE	
D1	UP 03.01.20	ADD D2012-117 FOR D130-701-041	
D2	UP 04.09.20	TACK WELD ANT-SKID AREA	

RELEASED
01.04.27 #

PARTS LIST FOR D2512 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH	LENGTH	DESCRIPTION
		A	B	
D2512-1	2	—	✓25.50	RIB
D2512-3	2	—	✓95.30	RIB
D2512-5	6	30.84	—	RIB
D2512-7	3 ✓	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRKT



UNDER REVIEW
08.02.05 PH
TUBING TO BE
CHANGED TO 0.065
WALL
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 37723A

D2512-1/-3/-5/-7

CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST 08.03.11
MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

Copyright © 1995 by DART AEROSPACE LTD

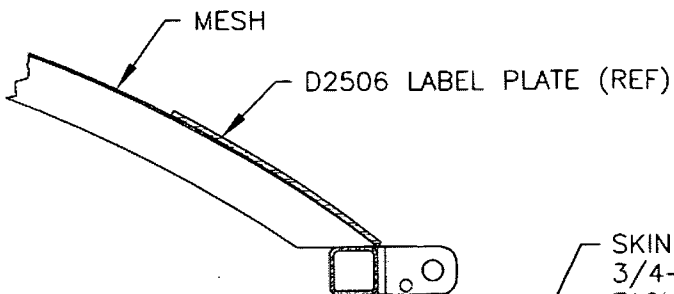
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART



DESIGN	BW	DRAWN BY	JF	DART AEROSPACE LTD
CHECKED	#	APPROVED	#	HAWKESBURY, ONTARIO, CANADA
DATE	01.04.19	DRAWING NO.	D2512	REV. D
		TITLE	BASKET LID ASSEMBLY (350/212)	SHEET 2 OF 4
		SCALE	1:20	

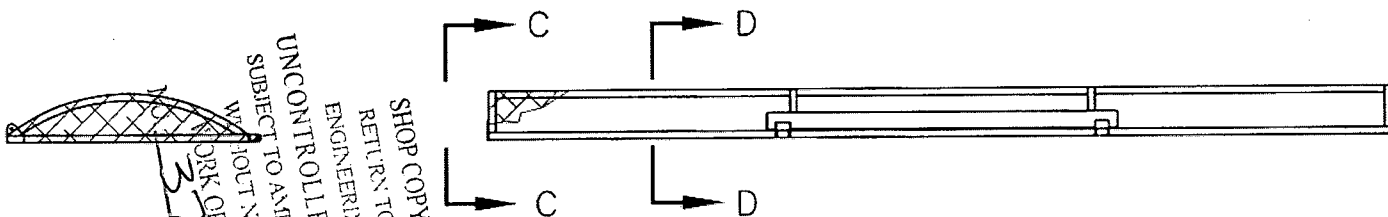
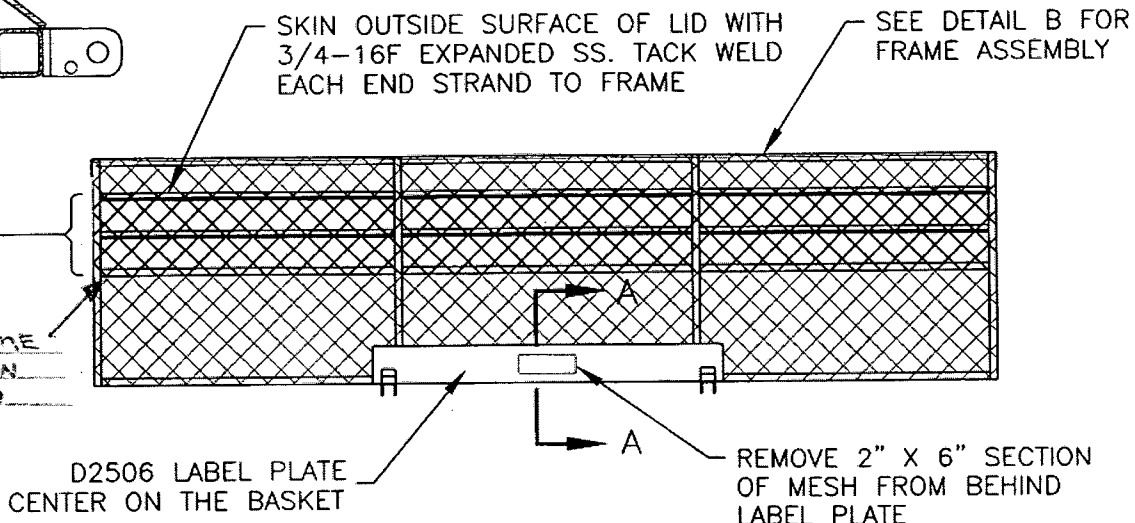
UNDER REVIEW
08.04.06
TUBING TO BE
CHANGED TO 0.045
WALL



SECTION A-A
(ROTATED 90° CCW)

FINISH THIS SECTION ALONG
ENTIRE LENGTH PER NOTE 3
AFTER POWDER COAT.

DZ TACK WELD MESH TO FRAME
AT EVERY AVAILABLE LOCATION
IN AREA TO BE ANTI-SKIDDED



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
37723A

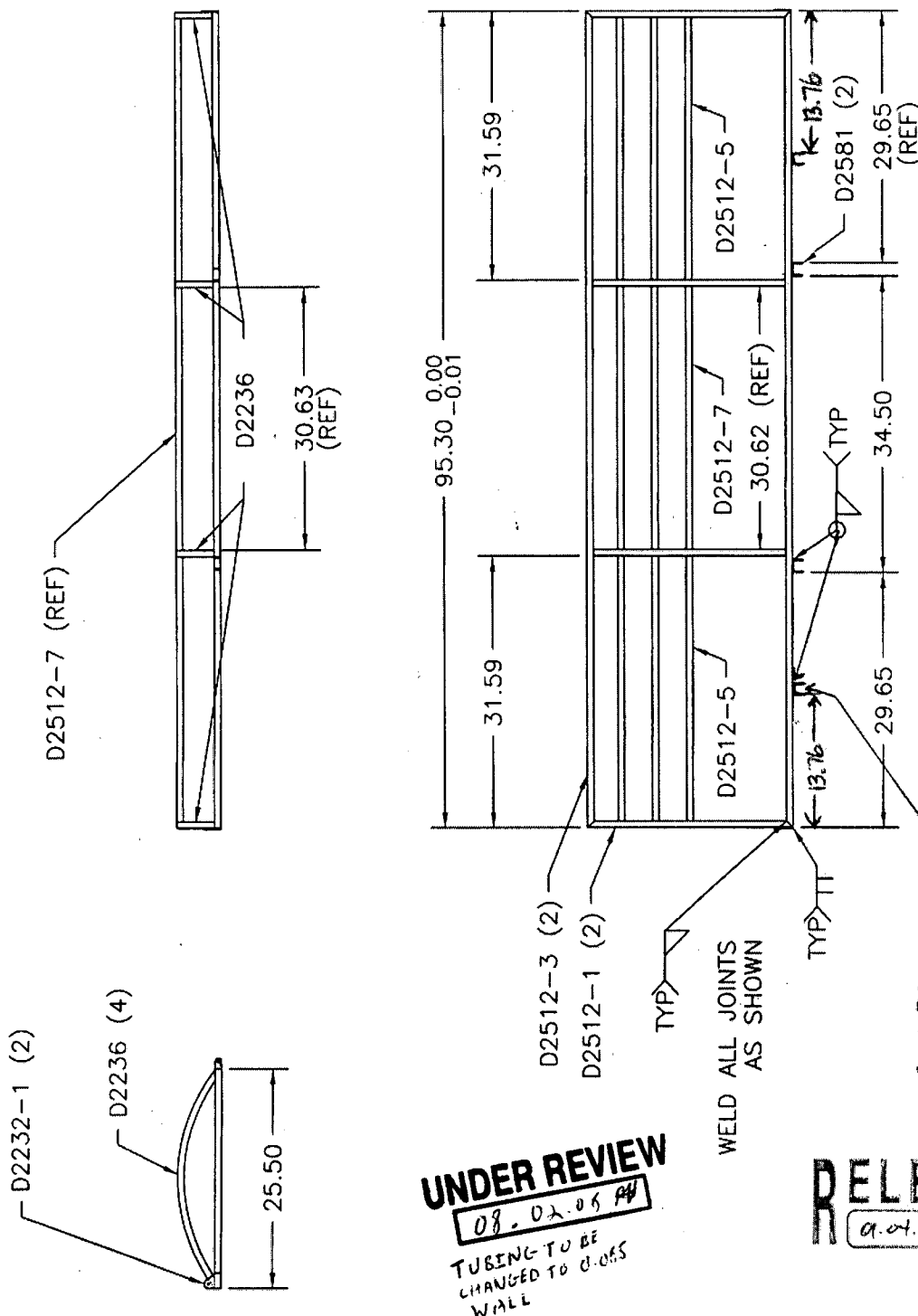
D2512 BASKET LID ASSEMBLY

- 1) MESH MATERIAL: 3/4-16F EXPANDED SS
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) SPRAY PAINT BLACK INSIDE SURFACE
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

RELEASED
01.04.25



DESIGN BW	DRAWN BY UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED A	APPROVED A	DRAWING NO. D2512	REV. D SHEET 3 OF 4
DATE 01.04.19	TITLE BASKET LID ASSEMBLY (350/212)		SCALE 1:20



DETAIL B
FRAMEWORK SHOWN FOR CLARITY
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

UNDER REVIEW
08.02.05
TUBING TO BE
CHANGED TO 0.055
WALL

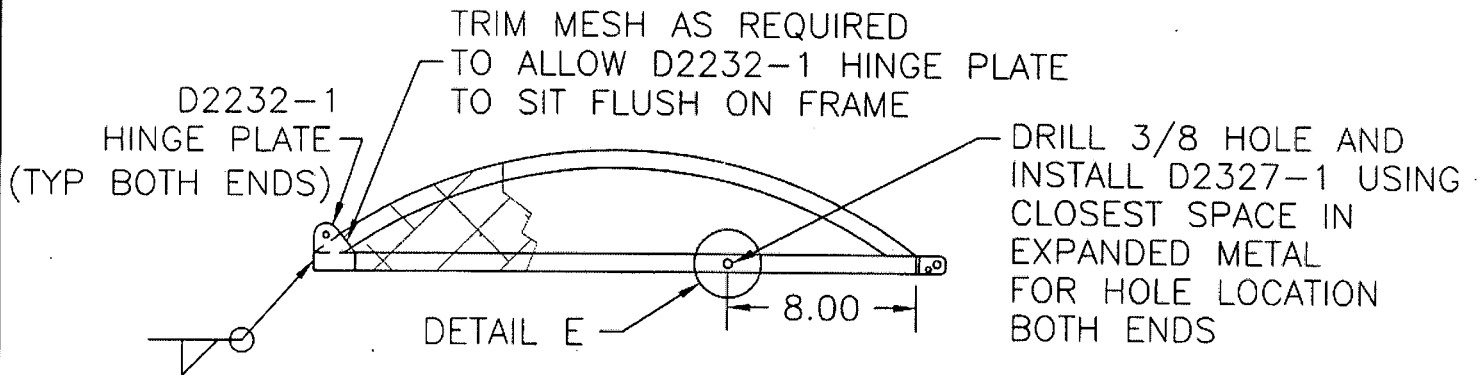
RELEASED
01.04.27
37723 A

Copyright © 1995 by DART AEROSPACE LTD

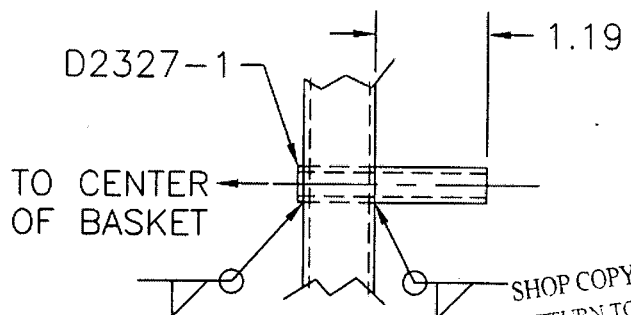
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



DESIGN BW	DRAWN BY UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2512	REV. D SHEET 4 OF 4
DATE 01.04.19		TITLE BASKET LID ASSEMBLY (350/212)	SCALE 1:8

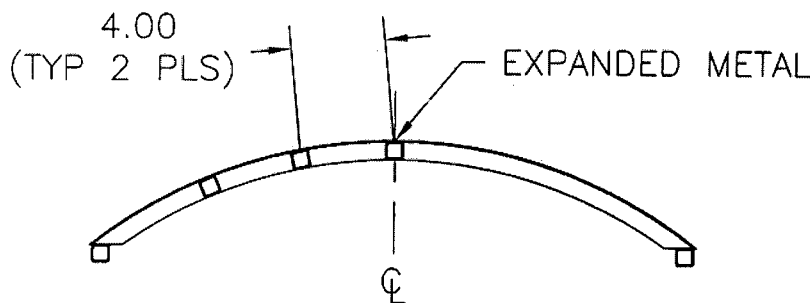


SECTION C-C SIMILIAR BOTH END RIBS



DETAIL E

SHOP COPY.
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 37723A



SECTION D-D SAME BOTH CENTER RIBS

UNDER REVIEW

08.02.05 AB

TUBING TO BE
CHANGED TO 0.045
WALL

RELEASED
01.04.27

Copyright © 1995 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Process Sheet

BASKET BASE ASS'Y LH

053041

053 ~~UNDER REVIEW~~

OK TO SHIP 05.03.11

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M304TS0750W065	304 SQ Tube.75x.75x.065W
-----	----------------	--------------------------



Comment: Qty.: 45.5000 f(s)/Unit Total: 45.5000 f(s)
304 SQ Tube.75x.75x.065W
Cut Rib from 3/4" x 3/4" x 0.063 wall 304/316 SS tubing.

Batch: ~~1105~~ SAD ~~12~~ 08/06/92 @

2.0	D31661	Basket Hoop.
-----	--------	--------------



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)
Basket Hoop
Cut
Qty. 5 D3166-1
Batch: 1337572 (4) B19951

SAD 08/05/12 SAD @

3.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Drill holes in D3053-3 as per Dwg D3053

2-Cut D3166-1 as per dwg D2235-3 detail

****Identify as D2235-3****

~~SECRET~~ / S40 08/05/92 *CB*

4.0	D23273	Spacer Bushing
-----	--------	----------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spacer Bushing

Pick:

Qty	Part Number	Description	Batch
2	D2327-3	Bushing	637541

FC 06 06 04

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3053-041 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR: <u>37723</u> <u>B</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>08/06/06</u>	<u>3</u>	<u>Mzde RH instead of LH base</u> <u>RC: Did not pay attention to W/O dwg or Part #</u>	<u>[Signature]</u> <u>08/06/06</u>	<u>change w/o to RH</u>	<u>U</u> <u>08/06/06</u>	<u>[Signature]</u> <u>08/06/06</u>	<u>[Signature]</u> <u>08/06/06</u>	<u>[Signature]</u> <u>08/06/06</u>

NOTE: Date & initial all entries

Date: Tuesday, 3/11/2008 7:52:48 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212 BASKET BASE ASS'Y LH

Job Number: 37723B

Part Number: D3053041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D22323

Basket Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Basket Hinge

Pick:

Qty Part Number Description
2 D2232-3 Hinge plate

Batch

336846

FL 08 06 04

6.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Mounting Bracket

Pick:

Qty Part Number Description
2 D2581 Mounting Bracket

Batch

337248

FL 08 06 04

7.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 50.4000 sf(s)/Unit Total : 50.4000 sf(s)

Expanded Metal Flat Stai

Pick:

Qty Part Number Description
48sq.ft M304EX0.75-16F Expanded Metal

Batch

M107856

SAN 08/06/04

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Remove all markings from material

Drill holes in three D2235-3 ribs as per Dwg D3053 using Jig DT8365

Weld as per Dwg D3053 using Welding Table and corner Jig Deburr as required

****Ensure ribs are positionned for LH****

FL 08/06/04

SAN 08/06/04

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

10.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

S 08/06/10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/11/2008 7:52:48 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212 BASKET BASE ASS'Y LH

Job Number: 37723B

Part Number: D3053041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Take Traveller D205-541-043 to KP

54

4 30 min

12.0

POWDER COATING

POWDER COATING



M107925



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

M-1 08

11/06/2008
S.007 09.21
#1 398.8
#2 B37723B
#3
#4 D3053041

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08/06/11 @

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: G-A

08/06/11 @

15.0

QC21

FINAL INSPECTION/W/O RELEASE



08/06/12

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-06-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

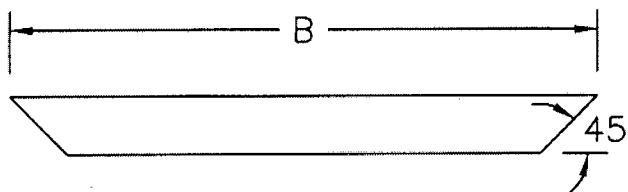
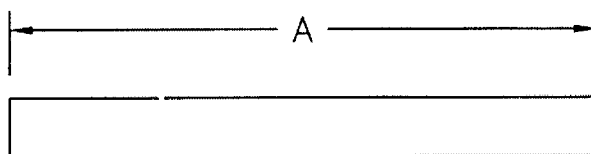


DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3053	REV. A SHEET 1 OF 3
DATE 01.11.01		TITLE BASKET BASE ASSEMBLY (212)	SCALE NTS
A	01.11.01	NEW ISSUE	

RELEASED
01.12.20 #

PARTS LIST FOR D3053-041/D3053-042 BASKET BASE ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D3053-1	2	—	96.00 ✓	RIB
D3053-3	2	—	25.50 ✓	RIB
D3053-5	6	✓23.73	—	RIB
D3053-7	3	✓25.31	—	RIB
D3053-9	3	✓19.48	—	RIB
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MOUNTING BRKT
D2232-3	2	N/A	N/A	HINGE PLATE
D2235-3	5	N/A	N/A	RIB



UNDER REVIEW

08.02.05 PH
TUBING TO BE
CHANGED TO 0.065
WALL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 37723B

NOTES:

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) FRAME MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING
- 3) MESH MATERIAL: 3/4-16F EXPANDED SS
- 4) WELD PER DART QSI 004
- 5) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES

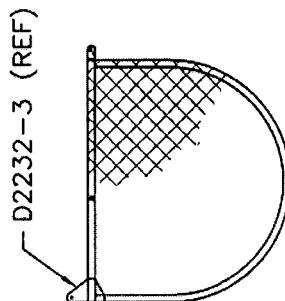
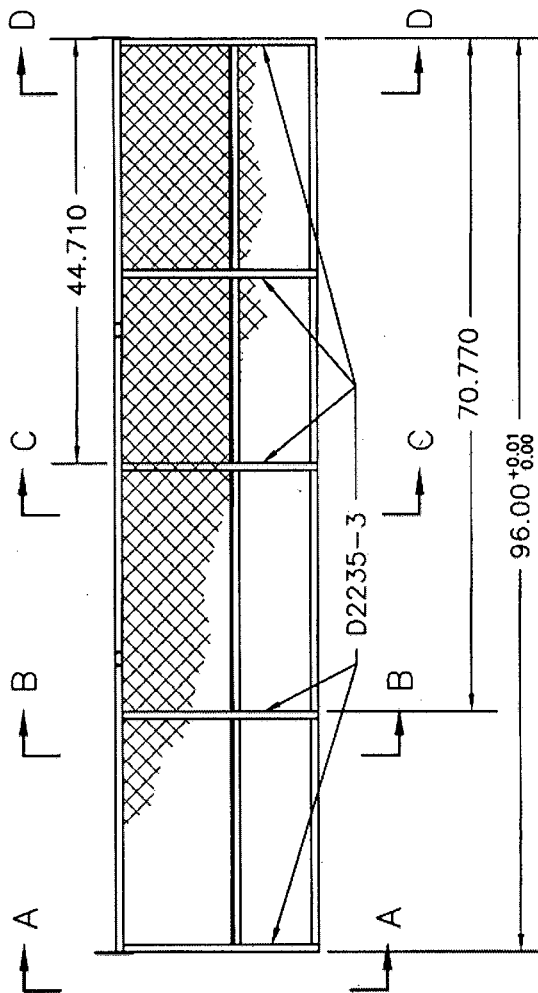
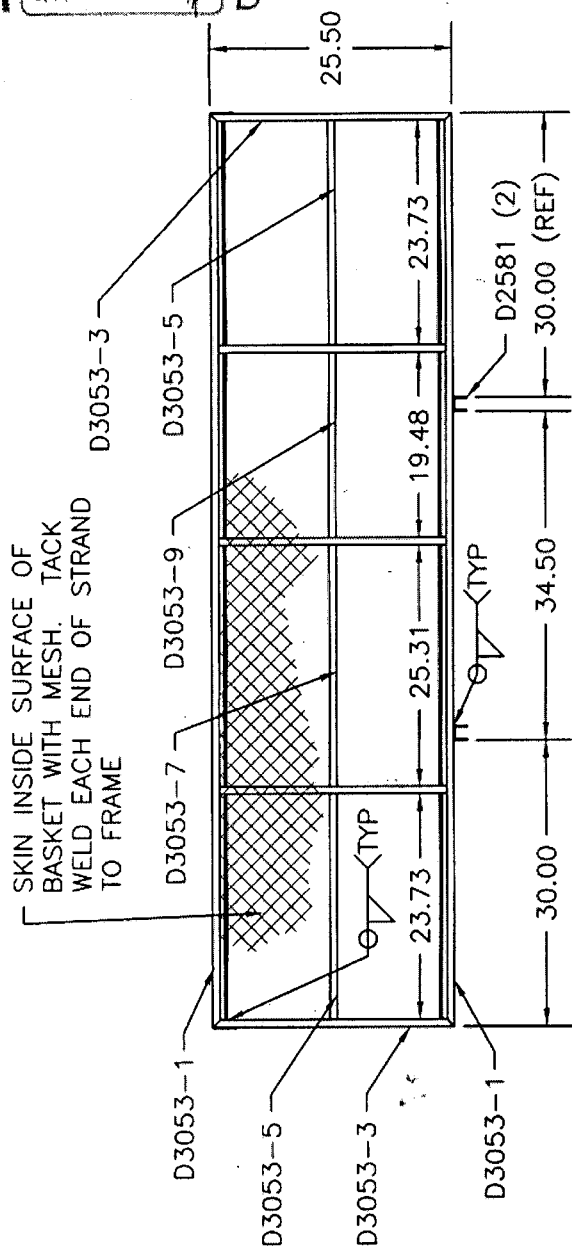
Copyright © 2001 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3053	REV. A SHEET 2 OF 3
DATE 01.11.01	TITLE BASKET BASE ASSEMBLY (212)		SCALE 1:20

RELEASED
d. 12.20 97



D3053-042 BASKET BASE ASSEMBLY SHOWN
(D3053-041 BASKET BASE ASSEMBLY OPPOSITE)

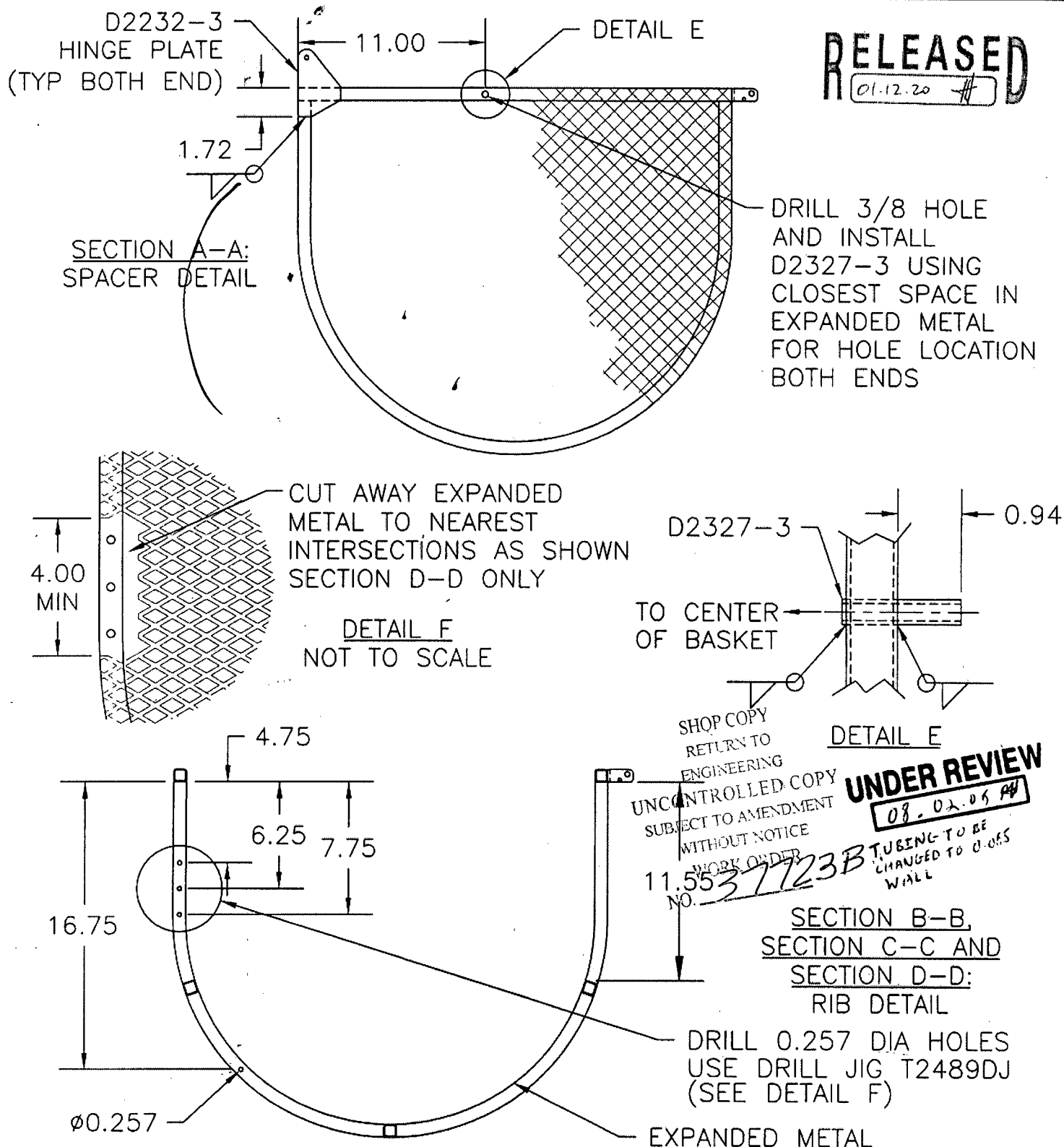
UNDER REVIEW
SHOP COPY
RETURN TO
ENGINEER
TUBING TO BE
CHANGED TO 0.065
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 37723B

Copyright © 2001 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3053	REV. A SHEET 3 OF 3
DATE 01.11.01	TITLE BASKET BASE ASSEMBLY (212)		SCALE 1:8



Copyright © 2001 by DART AEROSPACE LTD

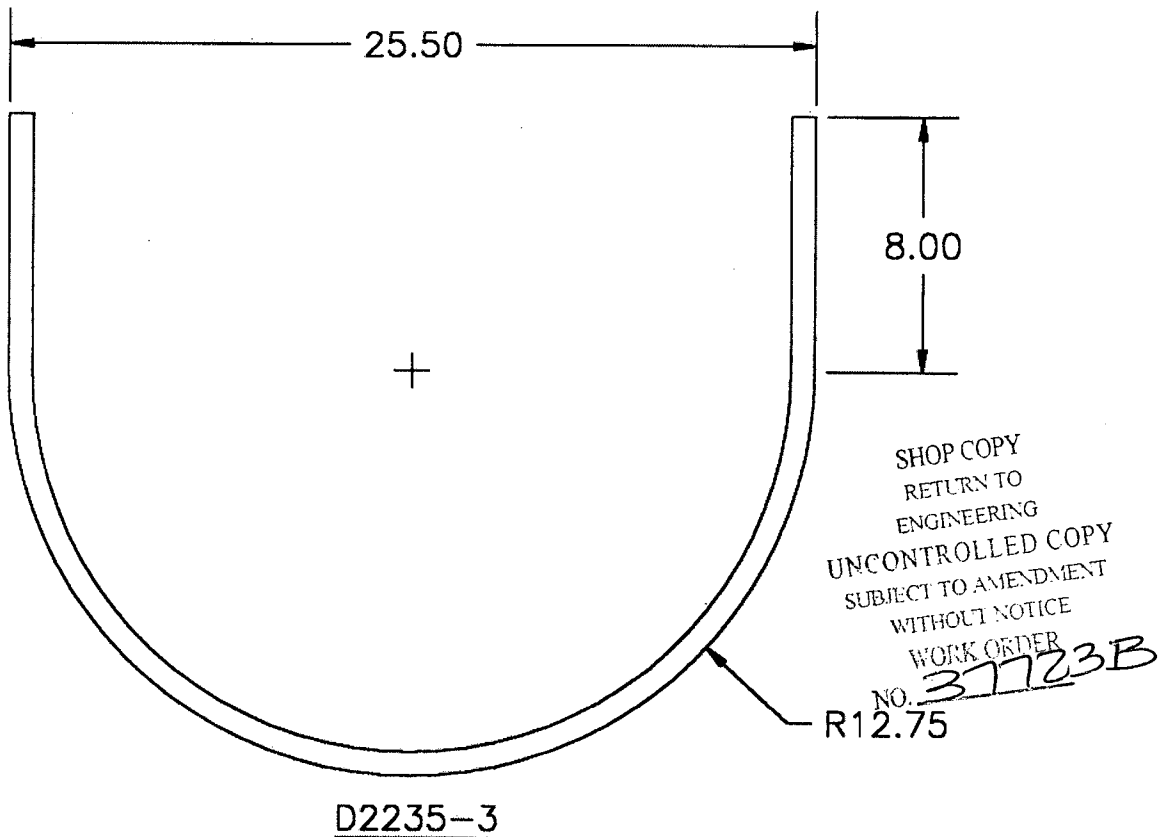
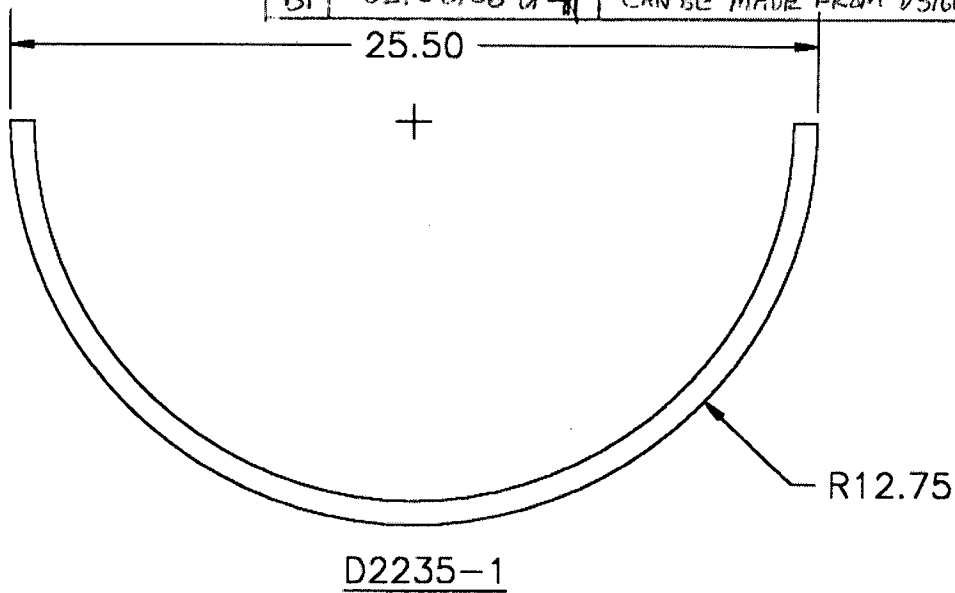
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	B WILLIAMS	DRAWING NO.	REV. B
CHECKED <i>SW</i>	APPROVED <i>BW</i>	D2235	SHEET 1 OF 1
DATE	TITLE		SCALE
94:12:16	BASKET RIBS		

BI	02.08.06 <i>11-11</i>	CAN BE MADE FROM D3166-1
----	-----------------------	--------------------------

RELEASED
R 960507



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *37723B*

CAN BE MADE FROM D3166-1 *BI*
MATERIAL: 304/316 SS, 3/4 X 3/4 X 0.063 WALL SQR.